

## ABSTRACT OF THE DISCLOSURE

A circular tubular heat pipe has a sealed structure closing a distal opening thereof. The improvement of the sealed structure provides a concave wall portion formed on the heat pipe adjacent to the distal opening. A pressed recess portion is formed on the concave wall portion adjacent to the distal opening, the heat pipe being formed to have a overlapping wall at the pressed recess portion. A volume reduced portion is formed on the pressed recess portion adjacent to the distal opening. A sealed welding portion is formed on the volume reduced portion at the distal opening, thereby reducing an area of the sealed welding portion. As the formation of the pressed recess portion and the volume reduced portion reduces the area of the sealed welding portion, the shrinking process is eliminated, and the welding time of the heat pipe with a large diameter is shortened.